

Work Order ID 86153

86153

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June-21-12 9:28:12 AM

Item ID: D412-769-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Facing Seat, RH

Start Date: 6/21/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/04/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-769	Rev C								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-769-042 CHG 001

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

1X
SD
12-7-4.

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

Environ

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Item ID: D412-769-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Facing Seat, RH

Start Date: 6/21/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/04/12 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-769-042

Location:

PPP Rev:

B

0.00

0.00

PP 86151

14

SD

12-7-11

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MLJ 12/07/11

MLJ 12/07/11

Picklist Print

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Work Order ID: 86153

Parent Item: D412-769-042

Parent Item Name: Aft Facing Seat, RH

Start Date: 6/21/12

Required Date: 7/04/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 08-07-17 new issue DD verified by:EC IPP Rev:B 10.03.23 as per IIN
revC DD verified by:EC IPP Rev:C 10.06.07 added pick kit DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8 D412-724-041 Head Rest Assembly, Center		Manufactured	No			105	Each	0.0000	1	1	82737		
5 D412-724-044 Head Rest Assembly, RH		Manufactured	No			105	Each	0.0000	1	1	85239		
8 D412-769-044 Aft Facing Seat Assembly, RH		Manufactured	No			105	Each	0.0000	1	1	81650		

RM

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011	60.0 lb	0.0 in	0.00 in-lb	87.0 in	5220 in-lb
Aft Facing Seat kit	27.2 kg	0.0 m	0.00 m-kg	2.21 m	60.11 m-kg
D412-769-041	30.0 lb	-16.1 in	-483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (normal position)	13.6 kg	-0.41 m	-5.58 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+16.1 in	+483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (normal position)	13.6 kg	+0.41 m	+5.58 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	-1.1 in	-33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (center position)	13.6 kg	-0.03 m	-0.41 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+1.1 in	+33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (center position)	13.6 kg	+0.03 m	+0.41 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	+13.9 in	+417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (right Position)	13.6 kg	+0.35 m	+4.76 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	-13.9 in	-417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (left Position)	13.6 kg	-0.35 m	-4.76 m-kg	2.21 m	30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

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Revision: C

Date: 09.11.26